Work Ord September-11-1		6863 M 646.	3911	*106	386.3*						Page 1
Item ID: Revision ID: Item Name:	646.3911 Shim	B 1 0 0	863	Accept	*N900	040	100)* s	etup Sta	1.7	S1* S2*
Start Date: Required Date: Reference:	9/23/13 : 9/23/13	Start Qty: 8.00 Req'd Qty: 8.00	*8	* 1124	Cust Item Customer:	ID:					
Approvals:		n: MLJ		Y- 12 Tooling: SPC (Y/N):		ate:		R	un Sta	n '' \]	R1* R2*
Sequence ID/ Work Center I		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	sion Nbr									
646.3900	N/C	<u> </u>	· · · · · · · · · · · · · · · · · · ·							 	
*110 *110*				0.00				12	0		Au
Waterjet FLOW CNC Water	jet	Memo 1-Cut as per Dwg Rev: Prog Rev:	Dwg V/C	0.00							13:11:0
•		2-Deburr if									
120 ·		QC2- Inspect parts off m	achine FAI/FAIB	0.00				. 0	^		A
120 QC Quality Control		Memo		0.00				12	_0_		13.11.

Quality Control

NCR: Y	es /	No				WORK ORDER NON-	100	NFORM	MANCE / UPI	DATE			•
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Work Orde	or.					DISPOSITION				AGAINST DI	EPARTMENT	/PROCESS	
Part No.						Rework Scrap Use-as-is		r	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing		Water Je Prod. Eng. Coor Rec/Store/Packaging		Engineering Quality Other
NCR No.				· · · · · · · · · · · · · · · · · · ·	Work Order Update].	Large Fab Composite				Supplier		
Root					Descri	ption of work order update		nitial	Act	ion	Sign &		
Cause	D	ate	Step	Qty	(or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
	LL			L		F	AUL	T CATE	GORY		. 1	1	1
Landi	ng Gear					General							
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube				o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Grain Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread			Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Ripples in Bend				ĺ	Drill Holes	1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 106863 Page 2 September-11-13 11:47:28 AM *N900040100* Item ID: 646.3911 Accept Setup Start **Revision ID:** Shim Item Name: 9/23/13 Start Qty: 8.00 **Start Date: Cust Item ID:** Required Date: 9/23/13 **Req'd Qty: 8.00 Customer:** Reference: Run Process Plan: _____ Date: ____ Tooling: Date: Approvals: Stop SPC (Y/N): QC: Date: Date: Set Up/ Tool ID Operation Tool # Plan Accept Reject Reject Insp. Sequence ID/ Number Stamp Run Hours Code Qty Qty Work Center ID Description QC8- Inspect parts - second check 130 *130* QC Memo Quality Control Outsource process-Cadplate per QSI017 4.1.9.1 0.00 140 CX 13/11/06/To *140* 0.00 Outsource3 Memo 21961 Issue P/O: Outsource process - Cad plate

0.00

0.00

Receive & Inspect for Damage & Mat'l Certs

Memo

150

150

Packaging

Packaging

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-	CONFORM	MANCE / UP	DATE			
									QA Closed:	Date:	
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update	Machining Small Fall Thermoforming Finishing		Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other
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Cause	Date	Step	Qty		or Non-conformance	Chief Eng	l .	ription	Date	Verification	QC Inspector
Ooc/Data Equip/Tooling Operator Material Setup Other Process Supplier Fraining Unapproved											
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}	Inspection Strip in Tube				Cut Too Short	Misread	1		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

• 1	
Work Order ID	10/0/3
Mark Cirder III	HINXA
MUIN CIUCI ID	LUUUUJ

400000

September-11-1				"10hXh.1"							
Item ID: Revision ID: Item Name:	646.3911 Shim			Accept	*N9000	14010	n* s	Setup Star Stop	I VI	S1* S2*	
Start Date: Required Date:	9/23/13	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item ID Customer:	:			IV.	5 /	
Reference: Approvals:		lan:	Date:	Tooling: SPC (Y/N):	Dat		F	Run Star Stop)	R1* R2*	
Sequence ID/ Work Center I 160 *160* QC Quality Control	D	Operation Description QC5- Inspect part compl	eteness to step on W/O	Set Up/ Run Hours S 0.00 27 9-89	Tool ID	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
170 *170* Packaging Packaging		Memo	ock Location: 55635	0.00 0.00 P-120 BY STAMPING THE	P# AND		_/3/	12/5	(12)	DAS 32 9-89	
180 *120* QC Quality Control		QC21- Final Inspection • Memo	- Work Order Release	0.00			· <u></u>	13,	12/9	4	

NCR: Ye	es / No				WORK ORDER NON-C	CON	IFORI	MANCE / UPI	DATE			•
						,		·		QA Closed:	Date:	
Work Order	r:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	į.	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	tion of work order update		nitial	Act	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
quip/Tooling												
Operator												
Material												
Setup												
Other						1				1		
Process	_											
Supplier		1				İ						
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	- 6					AUL	T CATE	GORY				
Landing	Bending				General Bend		Grain		_	Ovalized	F	7
	Centre No	ot Conco	atric to (\s -	BOM/Route	Н	Hardwa	uro.	<u> </u>	Over/Under	+-laranaa	Pressure/Forced
-	Cracks	Ji Concei	ithe to c	" -	Broken/Damaged	\vdash		ire ion Incomplete	<u> </u>	Part Incorred		Temperature/Cure Weld
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<u> </u>	Inspection		Tube		Cut Too Short	\vdash	Misread			Power Loss/		Other
<u> </u>	Ripples in	-			Drill Holes	\vdash	Offset			1 2 2337		1
			xtrusior	, <u> </u>	Drawing	-	ł	Calibration				
<u> </u>	Torque Waves in Extrusion Turning Sequence				Finish			Sequence				

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

Picklist Print

September-11-13 11:47:28 AM

Work Order ID:

106863

Parent Item:

646.3911

Parent Item Name:

Shim

Start Date: 9/23/13

Required Date: 9/23/13

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP REV:A 12.10.23 NEW ISSUE DD VERF:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MC1095S.032 C1095 Blue Tempered Spr	ing Steel Sheet .032	Purchased	No			110	sf	8.5000	0.03	0.2526312	Au	<u> 13.</u>	1 <u>1 · u</u> S
				Location MAT022	537	Loc Qty 8.5 8.5	<u>Lo</u>	c Code	12	353	7 —	> .	38

Page 1

										DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-C	ONFO	RIV	IANCE / UPDATE		,		•
										QA Closed:	Date:	
Work Ordei	r·				DISPOSITION			AGA	AINST DE	PARTMENT	/PROCESS	
Part No	Part No				Rework Scrap Use-as-is Work Order Update	Scrap Machining Small Fa Use-as-is Thermoforming Finishir		all Fab	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other	
Root			1	Descri	ption of work order update	Initia	ı	Action		Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng	Description		Date	Verification	QC Inspector
Doc/Data												
quip/Tooling		1					Ì					
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Landin	-			,	General	_				l.	F	1
	Bending			_	Bend	Grai			<u> </u>	Ovalized	_	Pressure/Forced
1	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hard			<u> </u>	Over/Under	tolerance	Temperature/Cure
	Cracks			ļ	Broken/Damaged	—		on Incomplete		Part Incorre		Weld
1	Crushed/	Crimped			Burrs	_		ons Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
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Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

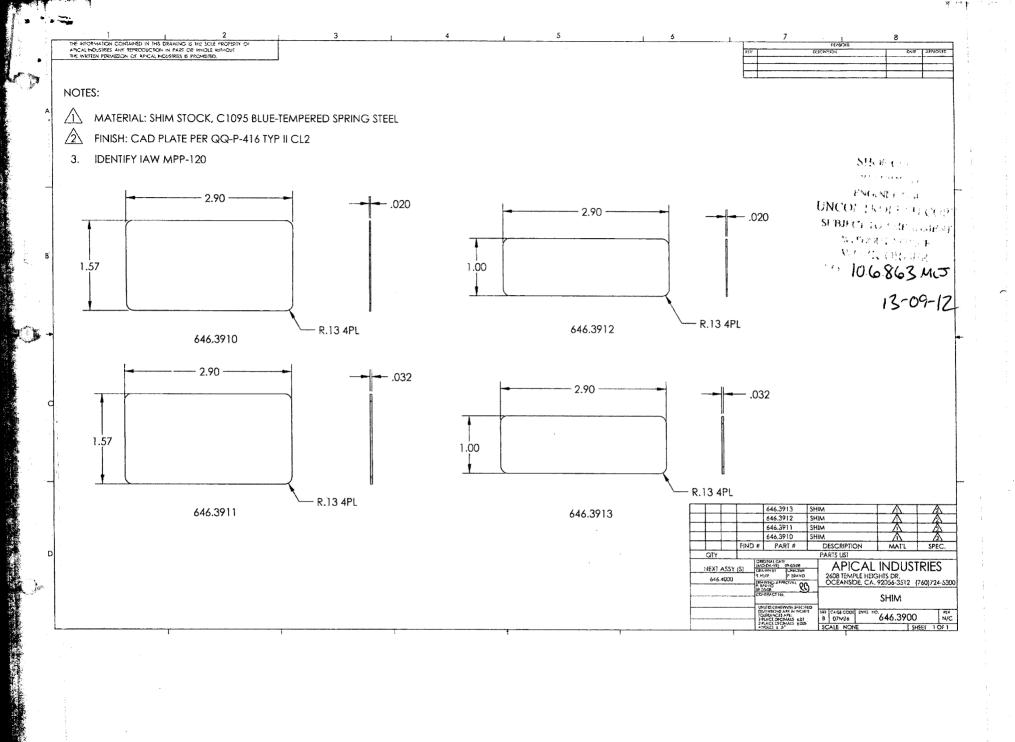
DART AEROSPACE LTD	Work Order:	106863
Description: Shim	Part Number:	646.3911
Inspection Dwg: 646.3900 Rev: N/C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.57	+/-0.005	1.57"			V	1/km-01
2.90	+/-0.005	2.90"				
0.032	+/-0.005	.032"			V	
			- DAS			
sured by:	7.1	Audited by:	27		Preliminary /	

Measured by:	4	Audited by:	27 9-89	Preliminary Approval:	
Date: /	3:11.02	Date:	131104	Date:	<u> </u>

Rev	Date	Change	Revised by	
Α	12.11.30	New Issue	KJ 🔭	M AA
			΄ ι	, , , , , , , , , , , , , , , , , , , ,



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GERTIFICATE OF CONFORMANCE

CADORATH PLATING CO. LTD. 2150 LOGAN AVENUE WINNIPEG, MANITOBA R2J-0J1

DATE:

Dec-02-2013

CONSIGNED TO: Dart Aerospace Ltd.

1270 Aberdeen St.

Hawksbury, ON K6A 1K7

W/O #:

130250

INVOICE #:

68742

CONTRACT OR

PURCHASE ORDER #

PO21961

DESCRIPTION:

SHIM

QTY

12

P/N # 646.3911

106863

CADMIUM PLATING IAW AMS-QQ-P-416C TYPE 2 YELLOW CLASS 2. BAKE HEAT CHART # 13-1051.

CERTIFICATE: I certify that the items indicated here on have been inspected and tested and conform to all specifications and requirements detailed on the contract or purchase order.



Approved Inspector: